

# Work Order ID 79408

Wednesday, January 25, 2012 3:06:13 PM

**\*79408\***

Feb 3rd

Page 1

Item ID: D206-642-612

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Float Skidtube RH

Start Date: 1/25/2012 Start Qty: 1.00

**\*1\***

Required Date: 1/31/2012 Req'd Qty: 1.00

**\*1\***

Reference: REWORK

Approvals: Process Plan: *mf*

Date: *12-01-25*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

<b>DART</b>		TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-89		FAX: 1-613-632-4443	
P/N	D206-642-612	CHG	CHG003
DESC	Float Skidtube RH	SIC	SH98-4
LOT	B35180	SIC	SA00475SE
MODEL	Bell 206A/B	SIC	
US PATENT # 5,735,384		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

IIN D206-642 O

150

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK D206-642-612 B 35180 *CHG 003*

REMOVE CAP AND WASH LPS3 OUT OF TUBE PER ECN 09-616

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

RE-ASSEMBLE I D2646 Air Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 *119508*

Sikaflex expire date: *12/08*

**B79408 D206-642-612**

*12 01 30 ①*

*12 01 31 ①*

*12 - 1 - 31*

# Work Order ID 79408

**\*79408\***

Page 3

Wednesday, January 25, 2012 3:06:13 PM

Item ID: D206-642-612

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Float Skidtube RH

Stop **\*NS2\***

Start Date: 1/25/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Identify as per dwg & Stock Location:

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER AND NEW CHANGE NUMBER

ADD NEW PAPERWORK

SP A-02-01

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

M.L.J 12/02/01

012-02-1

# Picklist Print

Wednesday, January 25, 2012 3:06:12 PM

Page 1

Work Order ID: 79408

Parent Item: D206-642-612

Parent Item Name: Float Skidtube RH

Start Date: 1/25/2012

Required Date: 1/31/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.27 Revised pick list KJ/EC  
 IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM  
 IPP Rev:D 07-12-05 ECN 1080p Rev:L DD verified by:ec  
 IPP Rev:E 09-01-06 update part list DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3672-5 Phenolic Washer		Manufactured	No				Each	1,864.0000		16			

Location	Loc Qty	Loc Code
ST060	1864	
35521	1075	
44679	220	
50354	569	

D3672-7 Phenolic Washer		Manufactured	No				Each	1,068.0000		16			
----------------------------	--	--------------	----	--	--	--	------	------------	--	----	--	--	--

Location	Loc Qty	Loc Code
ST060	1068	
73488	68	
76279	1000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

#### GENERAL NOTES:

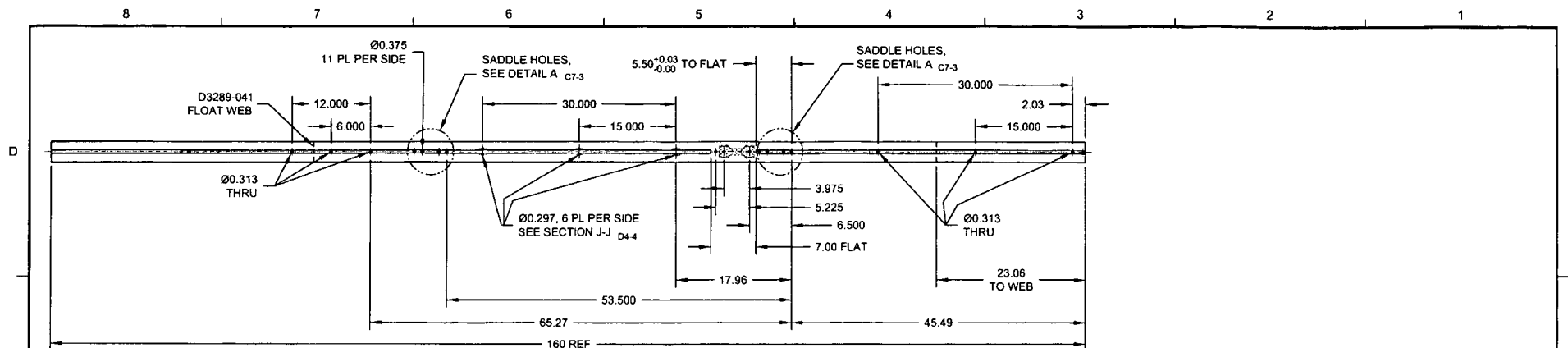
1. MATERIAL: N/A
2. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: NONE
7. WEIGHT: 20.8 LBS
8. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
9. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
10. ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
11. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291
13. WELDING: PER DART QSI 004
14. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED  
09/06/17

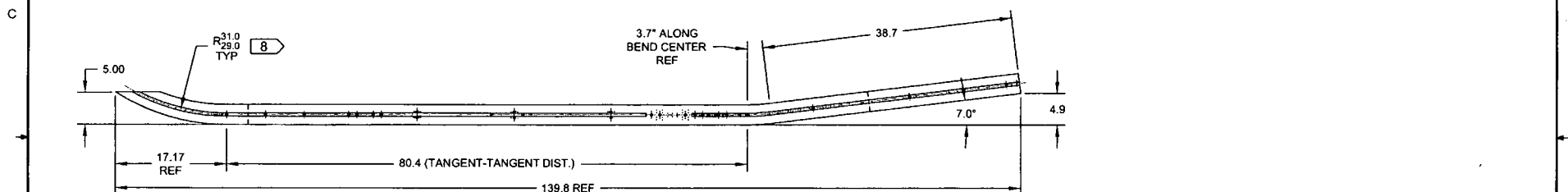
G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3288	REV. G SHEET 1 OF 4
TITLE SKIDTUBE ASSEMBLY	SCALE NTS
COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

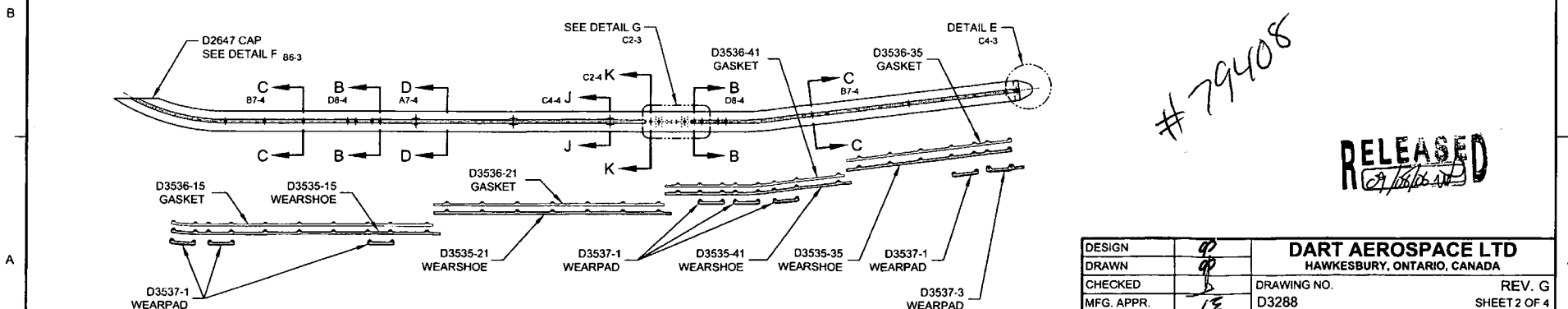
#79408



**D3288-041 DRILLING/WEB ASSEMBLY DETAIL**



**D3288-041 BENDING DETAIL**

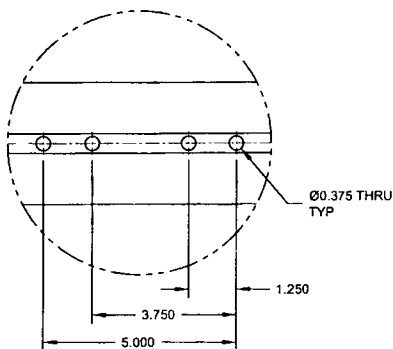


**D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY**

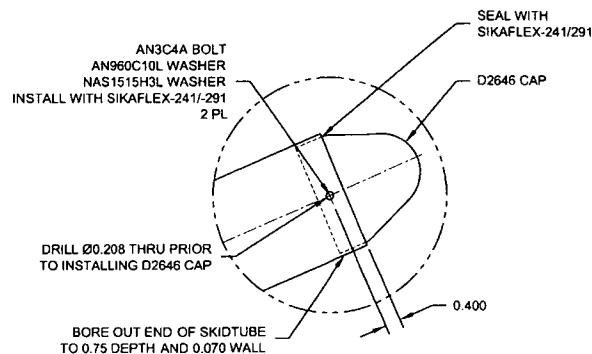
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

#79408

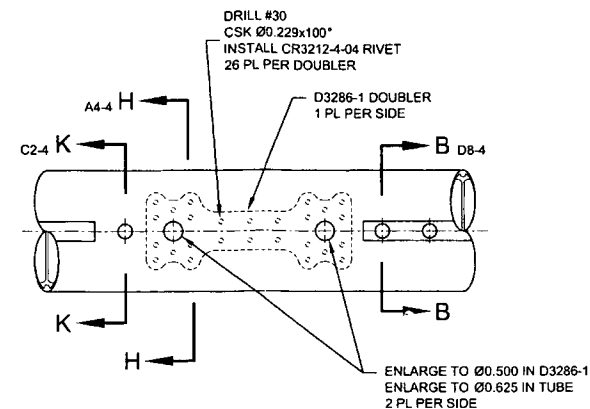
RELEASED



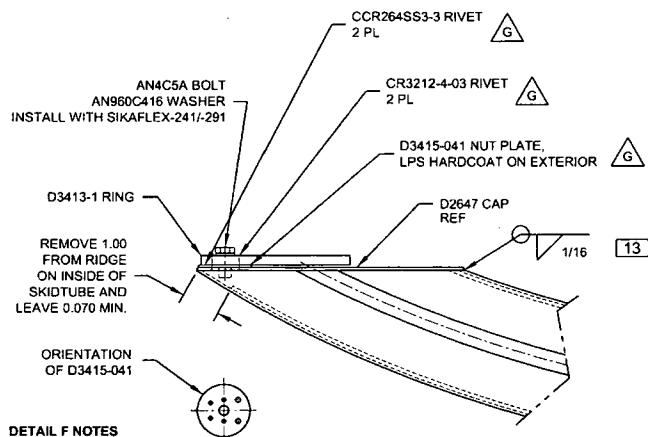
**DETAIL A: DRILL DETAIL** D6-2, D4-2  
SADDLE HOLES, SCALE 5X



**DETAIL E** B3-2  
SCALE 5X



**DETAIL G** B5-2  
SCALE 5X



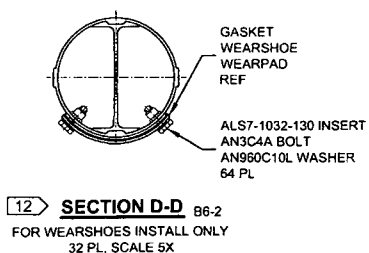
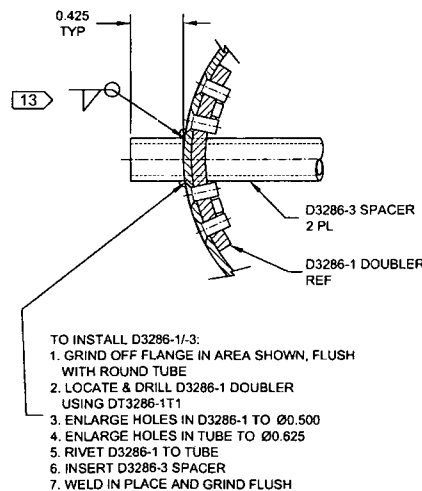
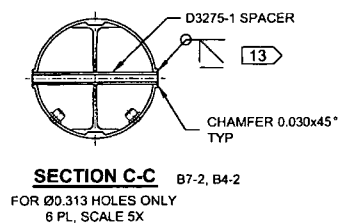
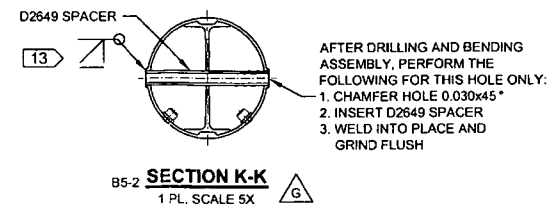
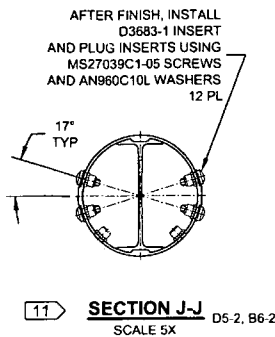
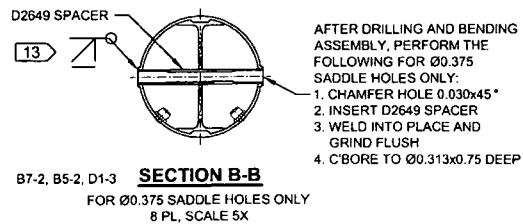
- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL** B7-2  
SCALE 5X

# 79408

**RELEASED**  
09/06/17

DESIGN	99	<b>DART AEROSPACE LTD</b>	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. G
MFG. APPR.	99	D3288	SHEET 3 OF 4
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



#79408

RELEASED  
09/06/17

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



4.9 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (D206-642)  
 32.19 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (ICA-D206-642)

ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -654	PART NUMBER	DESCRIPTION
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT

IS:

12B	16	16	16	16			D3672-7	WASHER
-----	----	----	----	----	--	--	---------	--------

WAS:

12B	16	16	16	16			D3672-5	WASHER
-----	----	----	----	----	--	--	---------	--------

# 79408

DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9467	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WASHER CHANGE	NTS
DATE	09.06.17	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

## Work Order ID 79408

Wednesday, January 25, 2012 3:06:13 PM

\*79408\*

Feb 3

Page

Item ID: D206-642-612

Accept

\*N900040100\* Setup Start \*NS1\*

Revision ID:

Item Name: Float Skidtube RH

Start Date: 1/25/2012 Start Qty: 1.00

\*1\*

Required Date: 1/31/2012 Req'd Qty: 1.00

\*1\*

Reference: REWORK

Approvals: Process Plan: *ME*

QC:

Date: 12-01-25

Tooling:

Date:

SPC (Y/N):

Cust Item ID:

Customer:

Date:

Date:

<b>DART</b>				TEL: 1-613-63
TRANSPORT CANADA APPROVAL # 09-69				FAX: 1-613-63
P/N	D206-642-612	CHG	CHG003	
DESC.	Float Skidtube RH	STC	SH98-4	
LOT	B35180	STC	SA00475	
MODEL	Bell 206A/B	STC		
US PATENT # 5735484				
CANADA FOREIGN PATENTS PENDING				
MADE IN C				

\*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

IIN D206-642

O

150

\*150\*

HandFinish

Hand Finishing

Memo

PULL FROM STOCK D206-642-612 B 35180

REMOVE CAP AND WASH LPS3 OUT OF TUBE PER ECN 09-616

0.00

0.00

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Quality Control

Memo

0.00

170

0.00

\*170\*

HandFinish

Hand Finishing

Memo

0.00

RE-ASSEMBLE I D2646 Alt Cap and seal with Sikaflex. Clean excess adhesive.  
 A/RSikaflex-291 11/15/08  
 Sikaflex expire date: 11/15/08

M.C.J 12/01/31

EB 12-01-31 03

AK 12 - 1 - 31